



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RBE105-31702W4-1
Job Sheet 185660



Part No: RBE105-31702W4-1

Job Qty: 5 ea

Part Name: Bolt



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/31/18

Job Tracking No:

Due Date: 12/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE105-31702W4 Rev.A. IPP Rev. A 18.10.30 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	12/14/18	12/14/18	0.00	0.00	Start Up Machining-3		JB 19-01-13
120	CNC Lathe	5 pcs	12/14/18	12/14/18	0.00	5.00	MORFLEX SL-154 FK		JB 19-01-13
130	QC	5 pcs	12/14/18	12/14/18	0.00	0.00	QC2 Machining-4		JB 19-01-13
140	QC	5 pcs	12/14/18	12/14/18	0.00	0.00	QC8 Machining-4		B.A 19-01-13
170	Outsource	5 pcs	12/14/18	12/14/18			GRO002-VC	10	GT 19-01-14
180	Packaging	5 pcs	12/14/18	12/14/18	0.00	0.00	Packaging2		JAN 2 2 2019
190	QC	5 pcs	12/14/18	12/14/18	0.00	0.00	QC6		38
200	Packaging	5 pcs	12/14/18	12/14/18	0.00	0.00	Packaging3-1		Dan 19-01-14
210	QC21-SA	5 Ea	12/14/18	12/14/18	0.00	0.00	QC21		DAS 19-01-14

Part Op 120 - 1-Machine as per DWG. FC 478 FOLIO REV: _____ DWG REV: _____ 2-Debur
Descriptions: 170 - Issue P/O to GROUPE ALTECH; PO 042252 -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required

GA134

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R0.875	AISI 4140 Quenched & Tempered Steel Round Bar 0.875" Dia.	1.3900 ft (.278 ea)	90-Start up Operation	S128382

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140QT-R0.875	1	9	0

ifications

Id not be found.

Plex 10/31/18 9:42 AM Dart.lajeunesse.marie



Container No: S144412



Part: RBE105-31702W4-1

Job No: 185660

Serial No/Batch: S144412

Revision: A

Inspector:

Exp Date:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				

RBE105-31702W4-1 INSPECTION SHEET

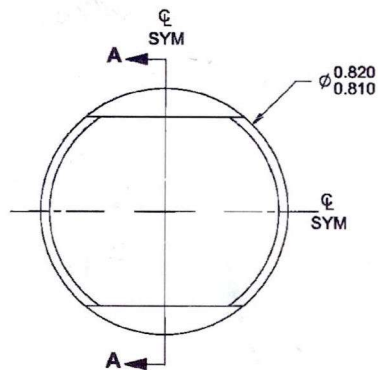
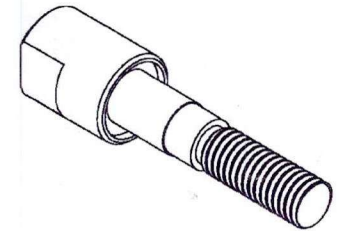
(GA 058)

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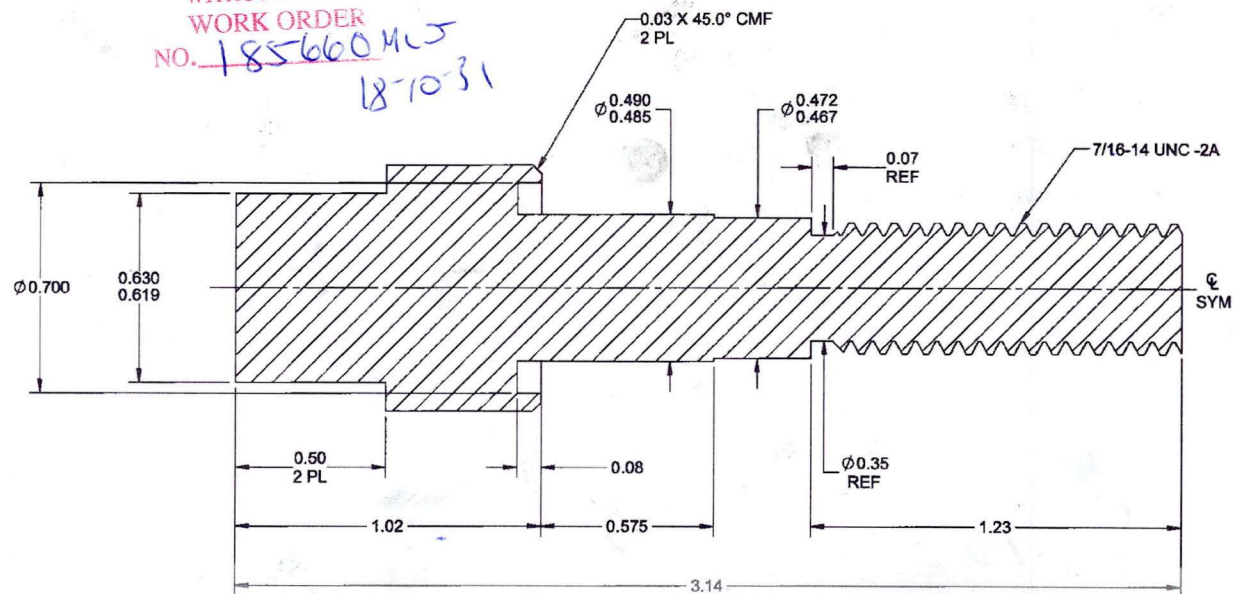
(If necessary)

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 185660 MJS
18-10-31



RBE105-31702W4-1 BOLT



SECTION A-A

NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = ± 0.1 " / $\pm 1^\circ$
 X.XX = ± 0.01 " / $\pm 0.5^\circ$
 X.XXX = ± 0.005 " / $\pm 0.1^\circ$
 X.XXXX = ± 0.0005 " / $\pm 0.05^\circ$
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005 "
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 " TO 0.010 "
- 7) IDENTIFICATION: N/A

DESIGN	KK	DART AEROSPACE LTD	
DRAWN	KK	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KK	TOOL PART #	REV. A
MFG. APPR.	FK	RBE105-31702W4	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE	10/29/2018	PRESSING-IN & PUSHING-OUT TOOL	NTS
COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO042252



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	185660	RBE105-31702W4-1	Bolt -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	1/22/19	5 pcs	0 pcs	5 pcs	\$2.35/pcs	\$11.75
Grand Total:										\$120.00	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

CT

DAS
38
9-89



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Certificat de Conformité / Certificate of Compliance

(015957-1)

Bon de Livraison / Packing Slip

015957 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.				
18-Jan-2019		Aman				042252				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)			CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBW109-3130-53-115 Rev.	RBW109-3130-53-115 BLACK OXIDE MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL AND WIPE OFF EXCESS			OXIDE-BLACK CH	9	9	0	0	0
2	RBE23007615-23 Rev.	RBE23007615-23 BLACK OXIDE MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL AND WIPE OFF EXCESS			BLACK-OXIDE CH	50	50	0	0	0
3	RBE105-31702W4-1 Rev.	RBE105-31702W4-1 BLACK OXIDE MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL AND WIPE OFF EXCESS			BLACK-OXIDE CH	5	5	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.